

Work Order ID 65156

Thursday, January 06, 2011 3:32:38 PM



Page 1

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

1.00

Start Date: 1/6/2011

Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011

Req'd Qty: 2.00

1.00



Customer:

Reference:

Approvals: Process Plan:

RL

Date: 1/01/7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3436	Rev A

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and
 Dwg D3436Dwg Rev: A Qty Part Number Description
 Batch A/RN/A 4130 Welding Rod M19317 Weld
 left step D3436-7 using welding Jig DT

1/11/09.06

1 ✓

110



BAND SAW

0.00

Memo

0.00

Jeaspa Bandsaw

1- Slit part D3436-041 on bandsaw as per Dwg D3436
 deburr

1/11/09.06

1 ✓

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Quality Control

1/12/09.06
 1/11/09.06

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Page 2

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Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
StampInsp.
Stamp

QC5- Inspect part completeness to step on W/O

0.00

84102166

0.00

(41)

LM

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

Apply black anti-skid paint as per Dwg D3436 and QSI005 4.4

START TIME: 11:45

OVEN TEMPERATURE: 400°F

FINISH TIME: 12:15

Wing Walk batch:

M118313

LX Ø m/l/11/09/06

4H

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1xwh 10 11/09/06

Work Order ID 65156

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Page 3

Item ID: D3436-043

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Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 1/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

155



Small Fab

Memo

0.00

0.00

Small Fab

Bond D3436-9 pads as per dwg and QSI 015

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

S 108107

(T) LH

170



Identify as per dwg & Stock Location:

0.00

Packaging

Packaging

Memo

0.00

119/120

Work Order ID 65156

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Page 4

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 1/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

11/9/11

ME
11-09-01

Picklist Print

Thursday, January 06, 2011 3:32:42 PM

Page 1

Work Order ID: 65156



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 1/6/2011

Required Date: 1/14/2011

Comments: IPP .A□ 05.05.11□New Issue□KJ/JLM□

Start Qty: 2.00

Required Qty: 2.00

Picklist Print

Thursday, January 06, 2011 3:32:42 PM

Page 2

Work Order ID: 65156



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3436-7



Manufactured No

160

Each

40.0000

1

2



Cap

1/11/09. 06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	40	
<u>56836</u>	40	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

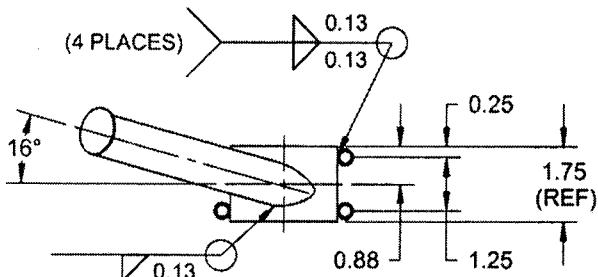
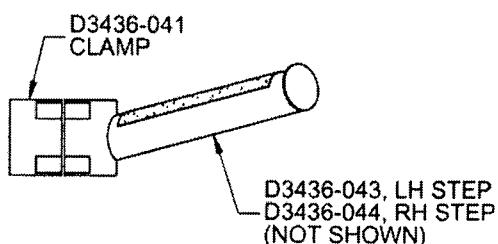
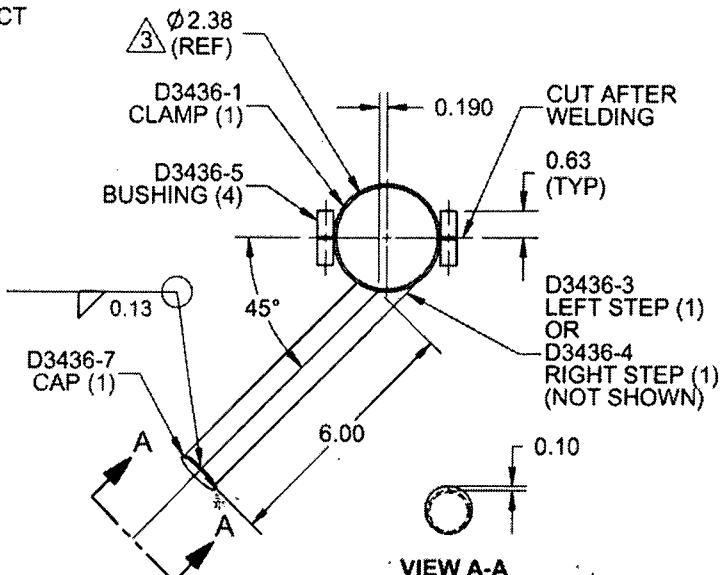
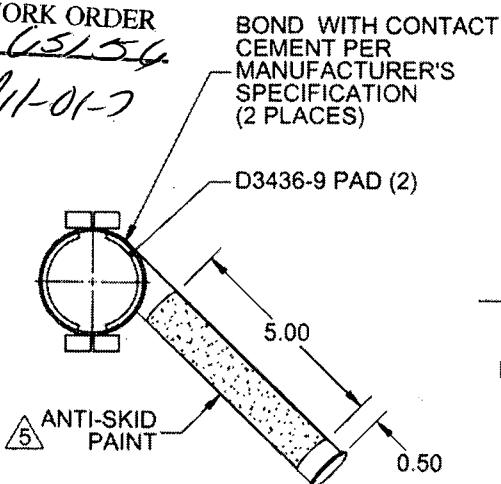
NOTE: Date & initial all entries

DARTSHOP COPY
RETURN TO
ENGINEERING

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE	05.04.28	TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDERNO. C5156RH1-01-7**WELDING****RELEASED**

05.05.27

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

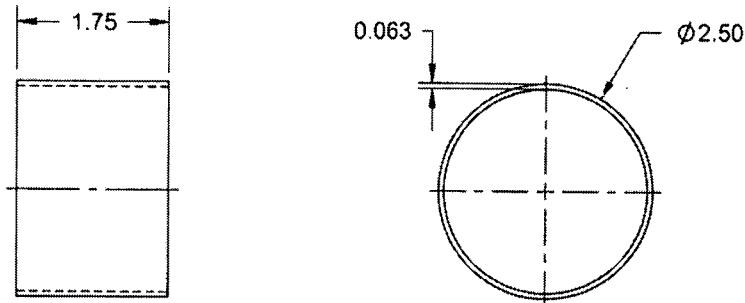
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2

W/0 65154



D3436-1 CLAMP

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 *ff*

D3436-1/ -5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

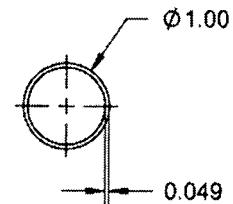
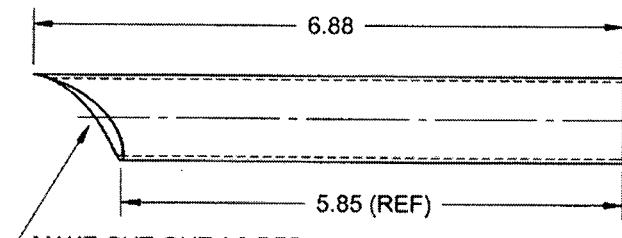
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2

W/0 05/54

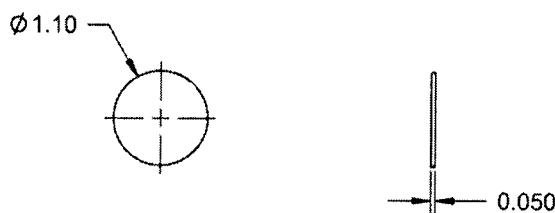


MAKE CUT-OUT AS PER
TEMPLATE DT8771

D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27

D3436-3/ -7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

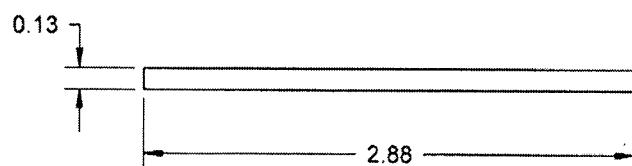
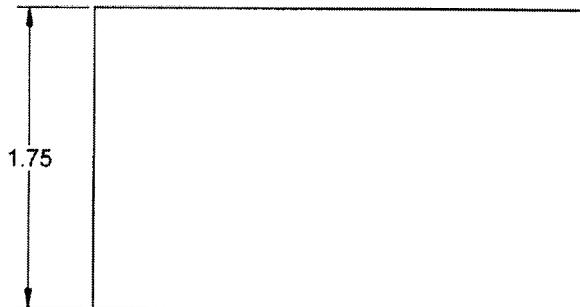
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1

W/665156



RELEASED
05-05-27 *MM*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries